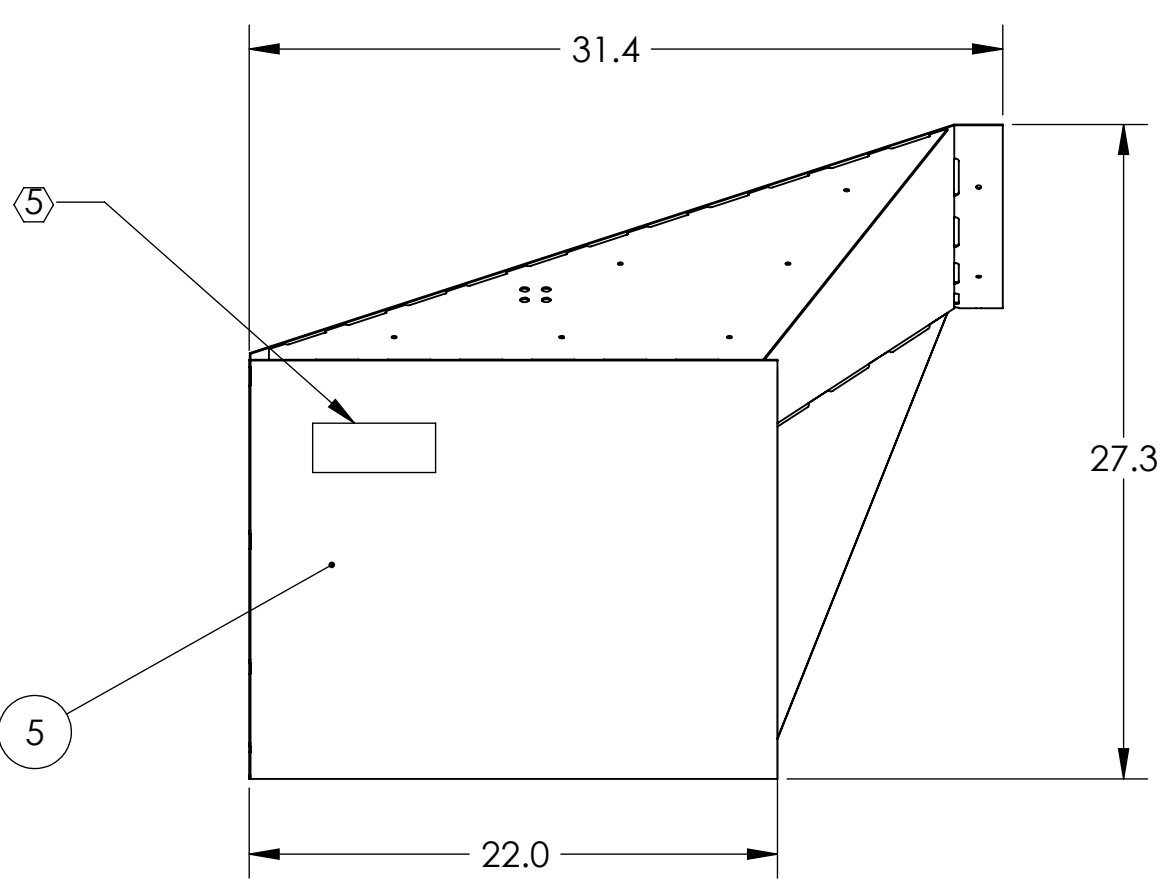
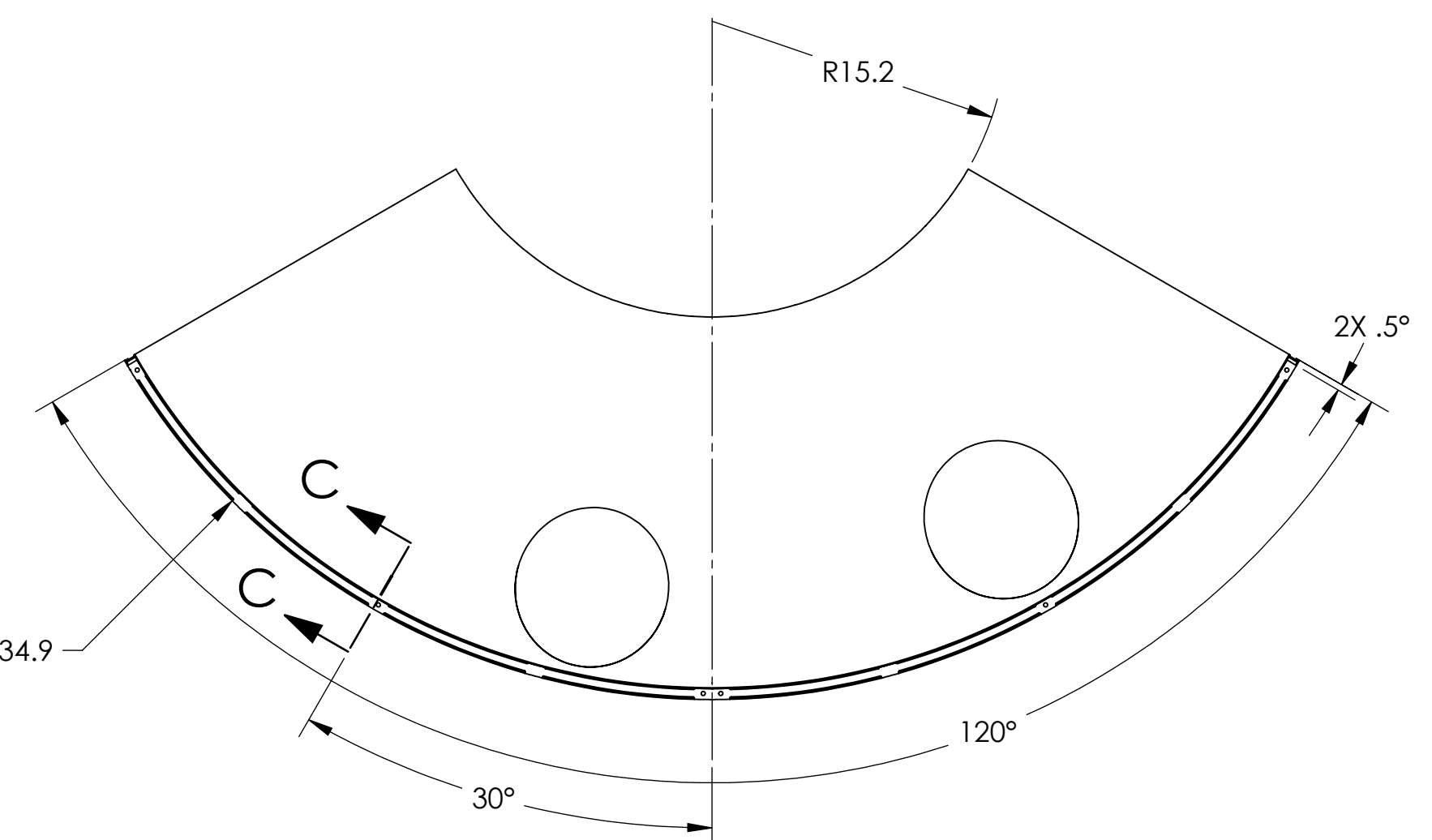
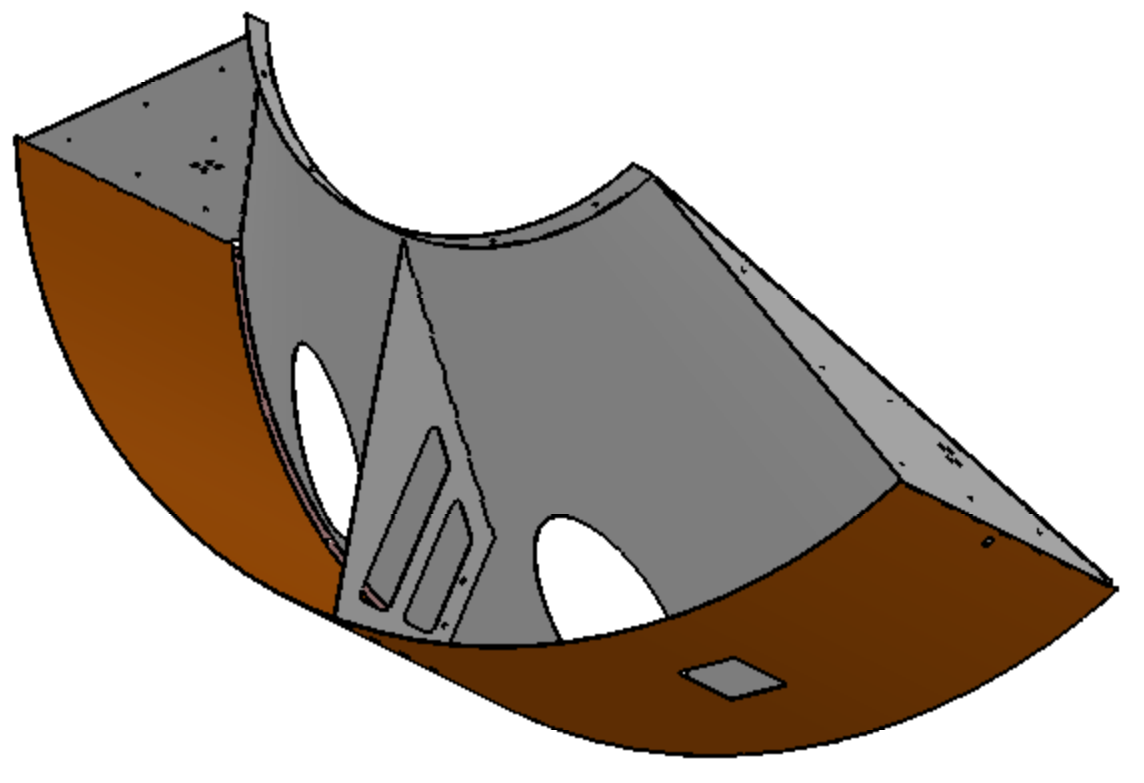
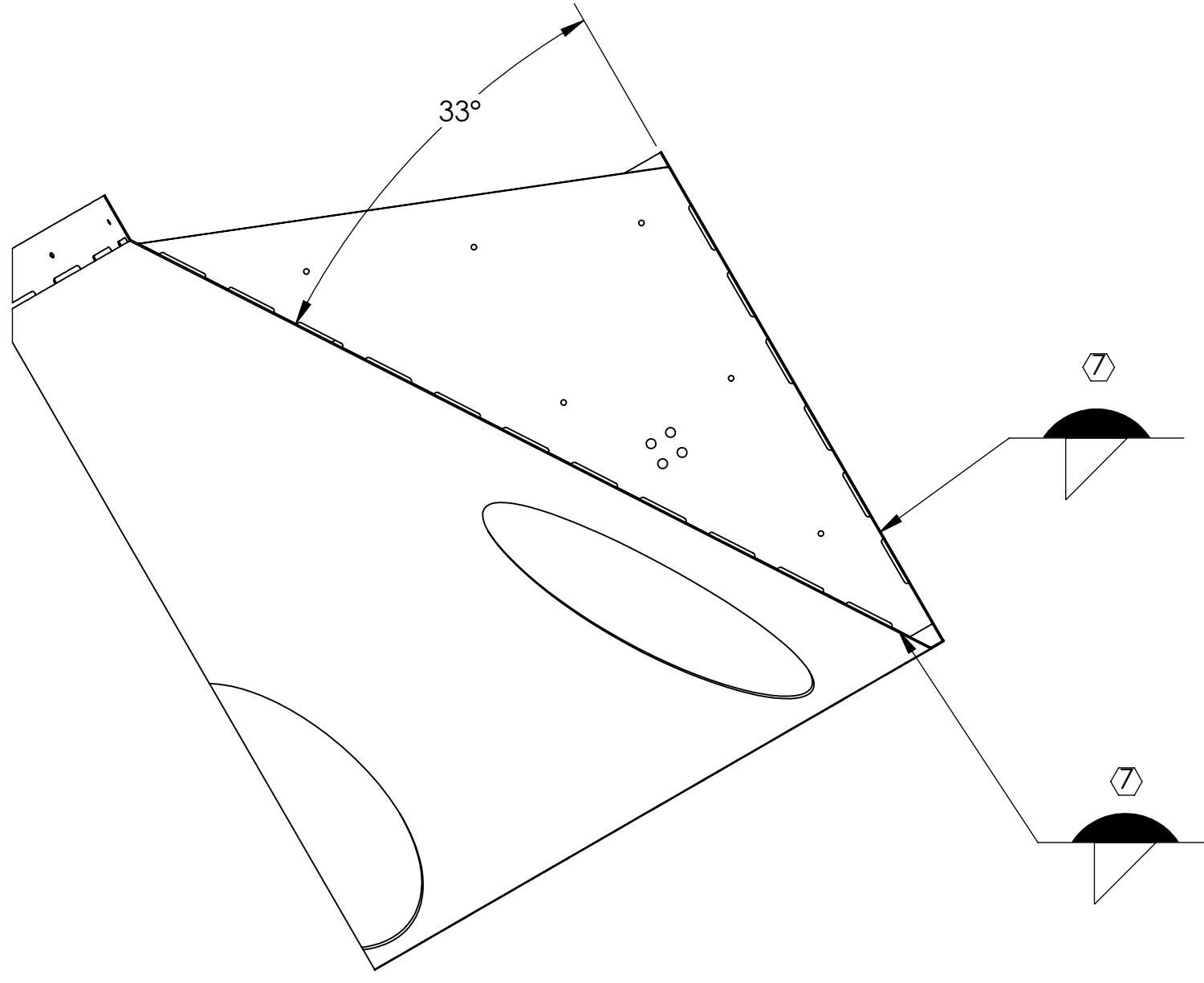
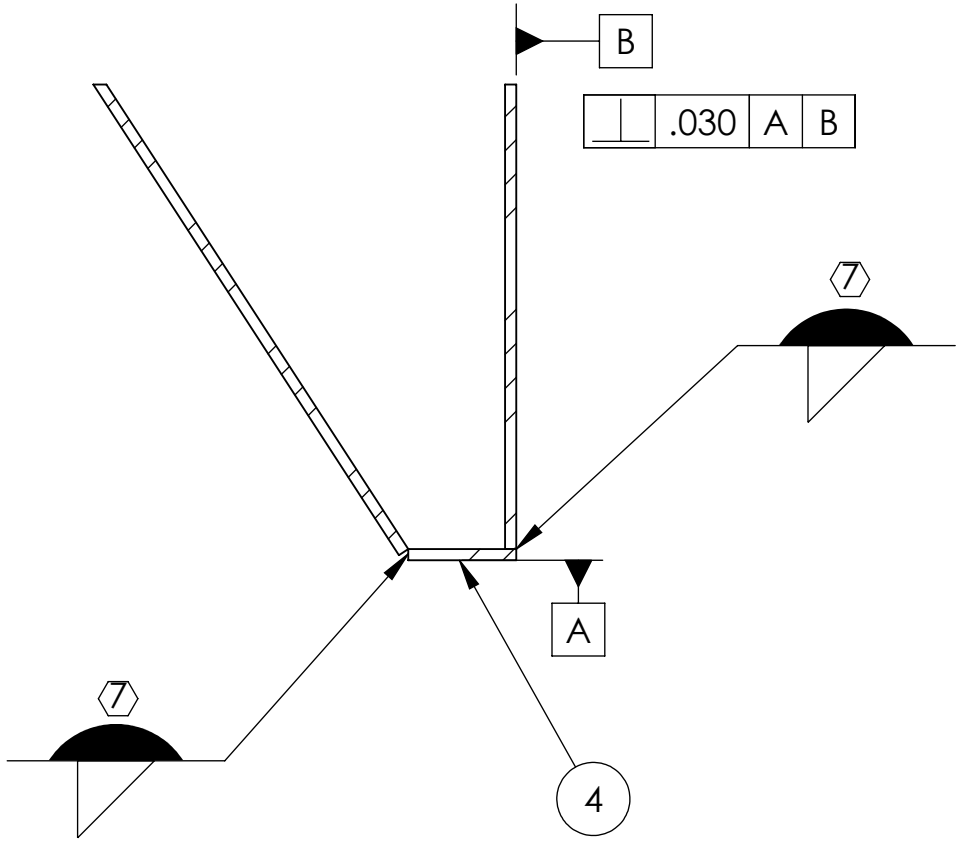
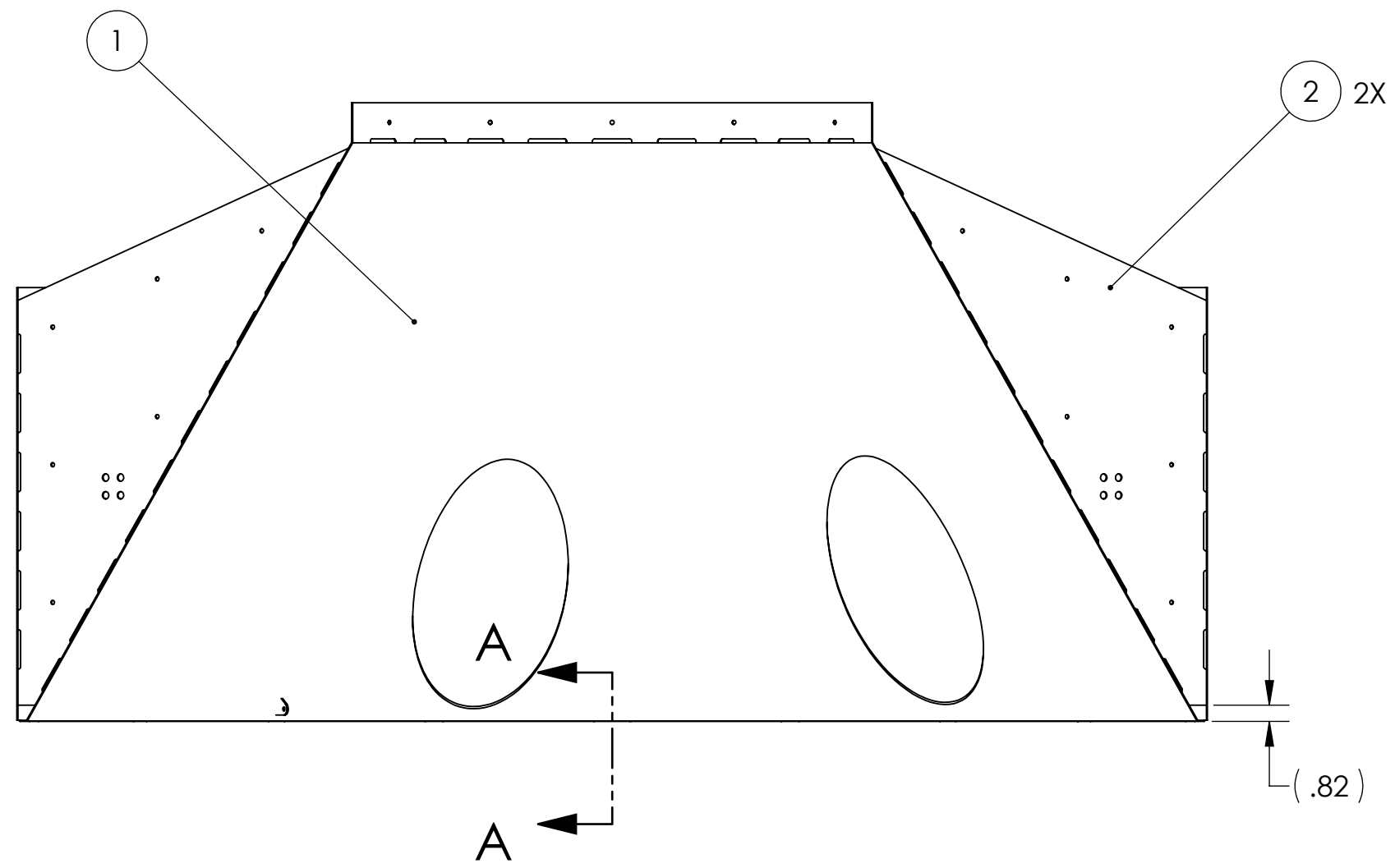
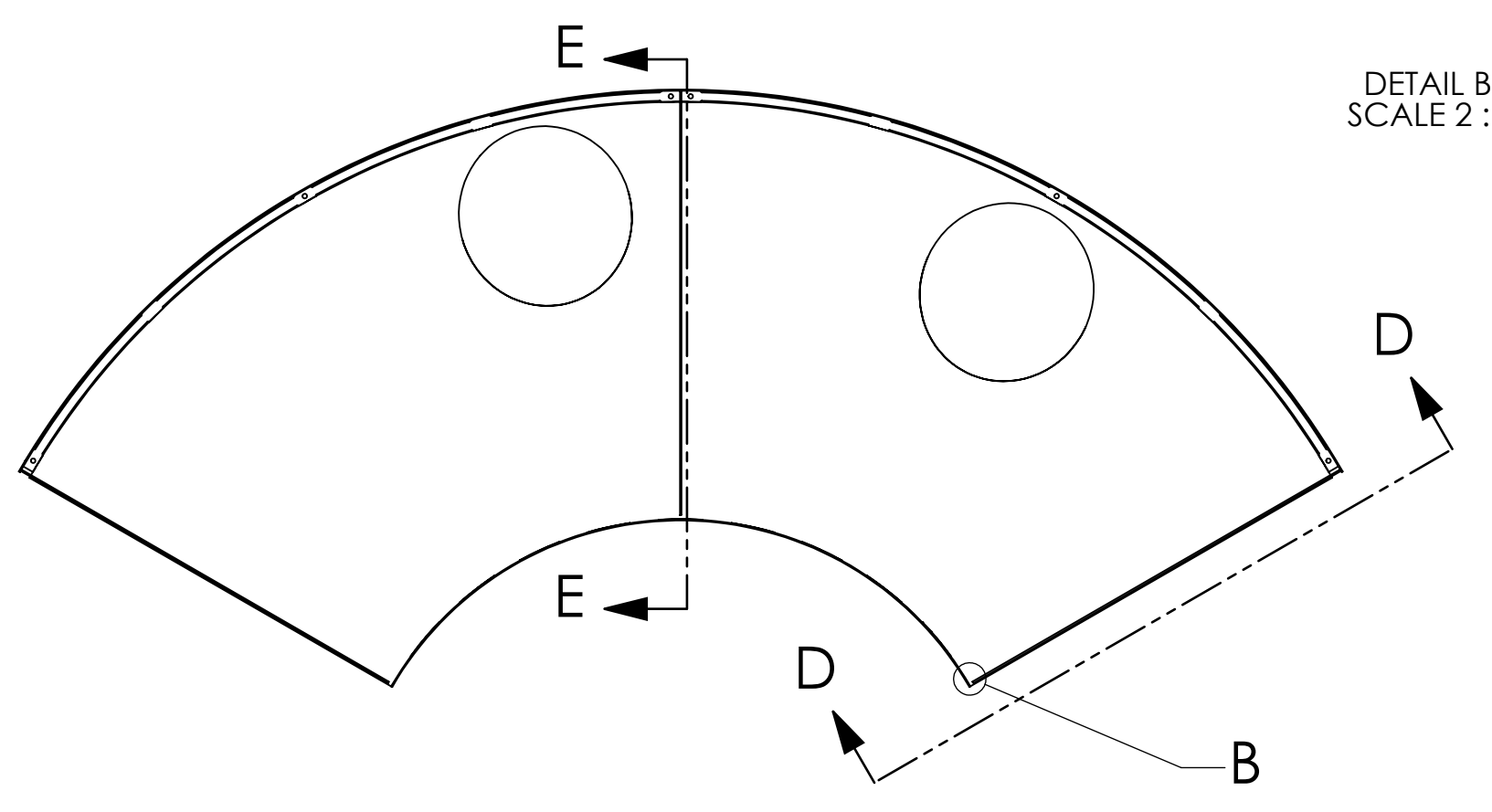
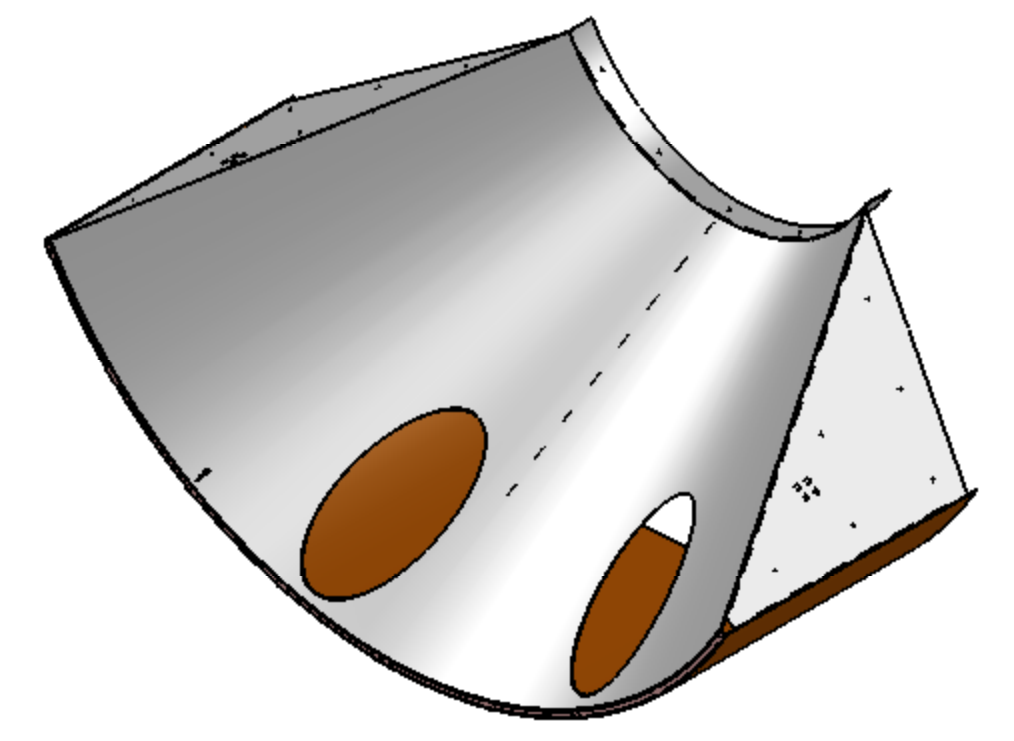
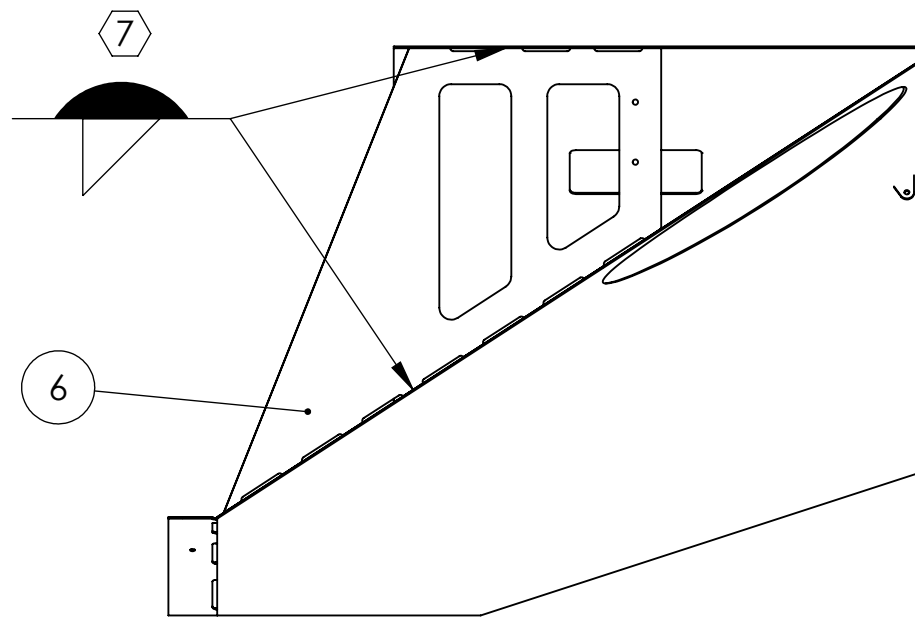
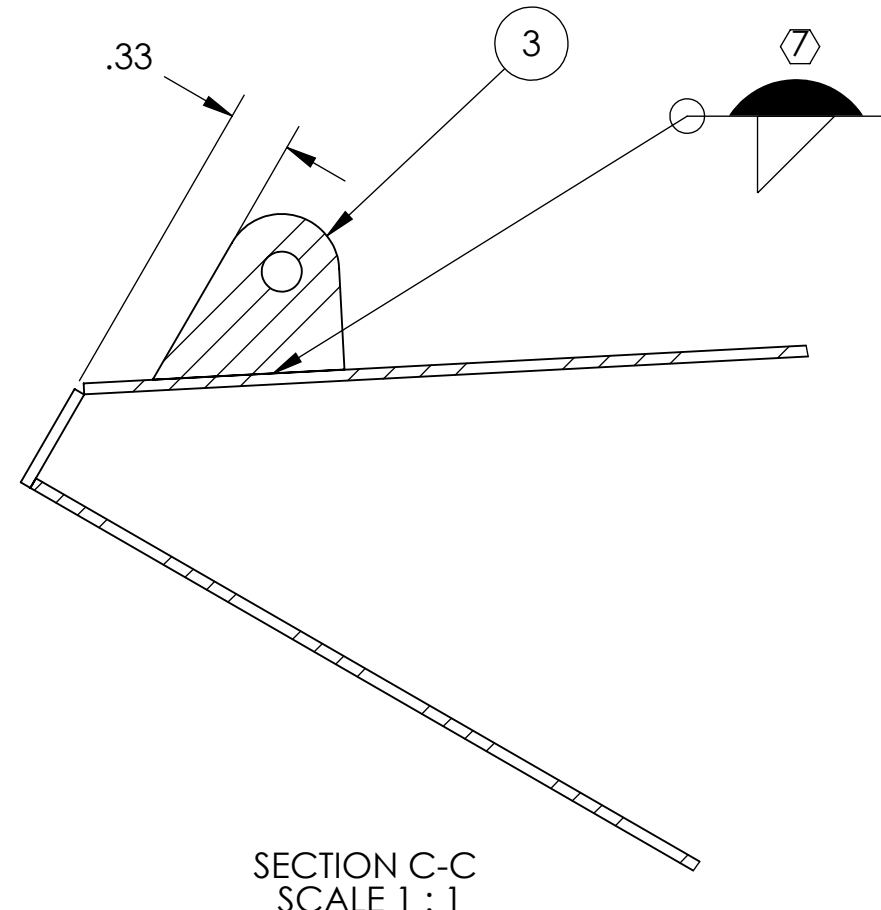
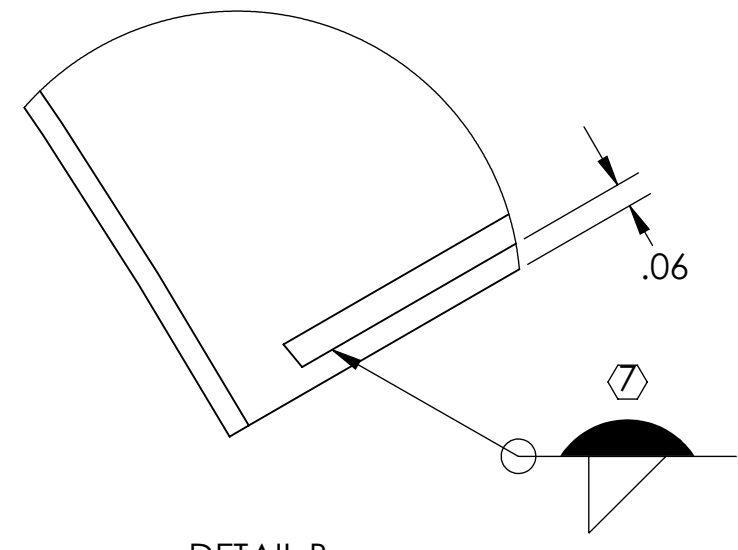


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000090
v2	9 MAY 2011	E1000360-v2	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		1
5	D1000558	RADIAL SEGMENT, LEFT	18GA A424 TYPE I STEEL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		1
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		2
1	D0902622	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT	18GA A424 TYPE I STEEL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

PART NAME: MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, LEFT

DESIGNER: H. KELMAN 20 MAY 2010
 DRAFTER: TQ. NGUYEN 07 SEP 2010
 CHECKER: M. SMITH 27 SEP 2010
 APPROVAL: D. COYNE

SIZE: D DWG. NO.: D0902656 REV.: v2

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

D0902656 at LIGO_Monfield_Cryo_Baffle_Segment_Weldment_ITMX_H1-H2_Left_PART_PDM_REV:K053_DRAWING_PDM_REV:K014